

Date: Tuesday, 23/12/2008 12:53:36 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL LOCK BASE
 Job Number : 44287
 Estimate Number : 11345
 P.O. Number :
 This Issue : 23/12/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D33701
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3370 REV C
 Previous Run : 37186 Drawing Revision : C
 Written By : Due Date : 20/01/2009 Qty: 4 Um: Each
 Checked & Approved By :
 Comment : Est. B 05.05.25 Added Powder Coat KJ/JLM
 Est Rev:C 08-07-17 revC as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X02500 6061-T6 Bar 1.50 x 2.50



Comment: Qty.: 0.3657 f(s)/Unit Total: 1.4629 f(s)

6061-T6 Bar 1.5" x 2.5"

M 10974

08/01/05

(4)

2.0 HARDINGE



HAAS

HARDINGE CNC LATHE SMALL



Comment: Machine D3368-1 as per Folio FA499 and Dwg D3368

Identify as D3368-1

Deburr

J.F. 08/01/07

(4)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/07

(4)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L. 09/01/07

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

F.L. 09/01/08

(4)

6.0 POWDER COATING /POWDER COATING



M18052



(4X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

3:00

M.L. 09/01/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 12:53:36 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 44287

Part Number: D33701

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE:

FINISH TIME:

320 OF
3:30

M-L

09/01/09

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 485

9/1/12

SP
(4x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44287
Description: Pedal Lock Base		Part Number:	D3370-1
Inspection Dwg: D3370 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	✓			
0.202	+/-0.010	.212	✓			
0.592	+/-0.010	.592	✓			
0.550	+/-0.010	.543	✓			
0.760	+/-0.010	.753	✓			
1.50	+/-0.030	1.497	✓			
1.188	+/-0.010	1.192	✓			
1.232	+/-0.010	1.226	✓			
R0.500	+/-0.010	R.500	✓			
2.35	+/-0.030	2.355	✓			
1.920	+/-0.010	1.921	✓			
0.450	+/-0.010	.448	✓			
1.673	+/-0.010	1.671	✓			
2.638	+/-0.010	2.634	✓			
4.00	+/-0.030	4.000	✓			
Ø0.203	+0.005/-0.000	Ø.204	✓			
0.250	+/-0.030	.240	✓			
1.450	+/-0.005	1.451	✓			
0.450	+/-0.010	.450	✓			
15°	+/-0.1°	15°	✓			

Measured by: J.F.	Audited by: JL	Prototype Approval:	N/A
Date: 09/01/07	Date: 09/01/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	

8 7 6 5 4 3 2 1

△
C

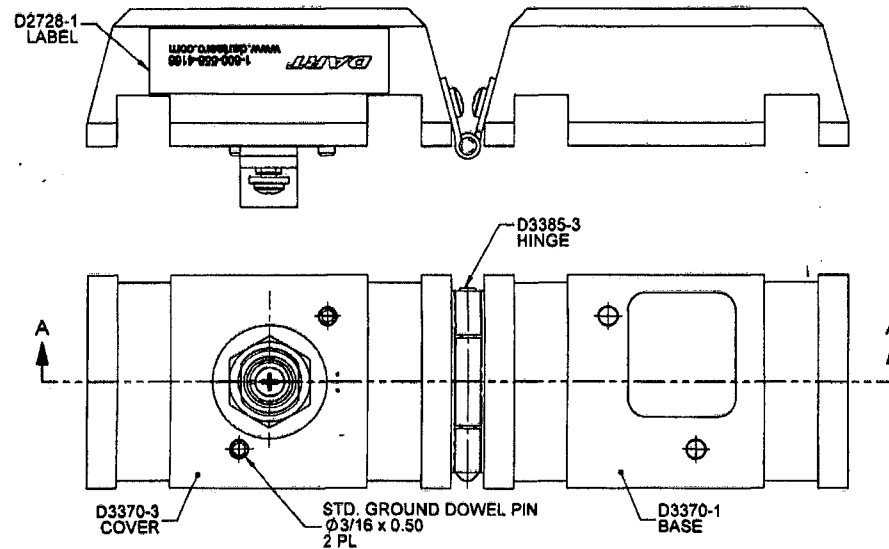
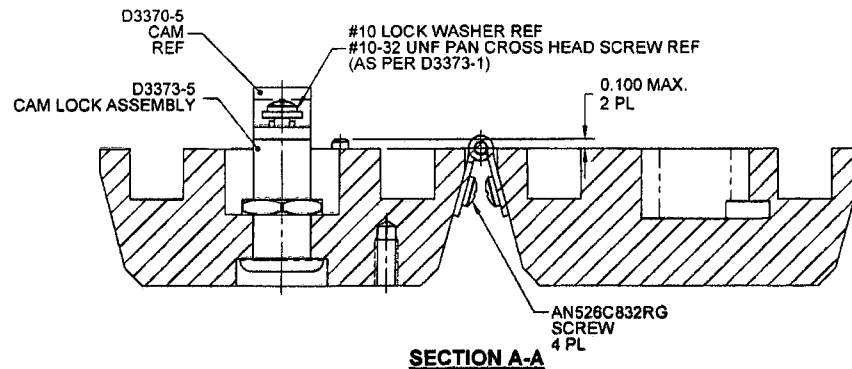
Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN980-416	WASHER
	1	D2728-7	LABEL
	1	D3370-1	BASE
	1	D3370-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

web 44287

RELEASED
08-07-16

C	SHEET 1 ADDED P/L. ADDED -041 TO P/L (SEE NCR 284). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.		AJS	08.07.11
B	D3385-3 WAS D3385-1		MB	05.03.22
A	NEW ISSUE		RF	04.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3370	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		PEDAL LOCK	NTS	
DATE	08.07.11	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

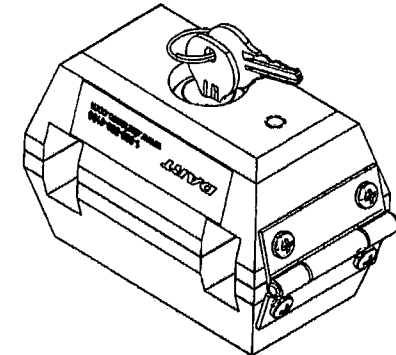
8 7 6 5 4 3 2 1



D3370-051 PEDAL LOCK ASSEMBLY

NOTES:

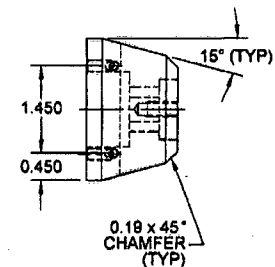
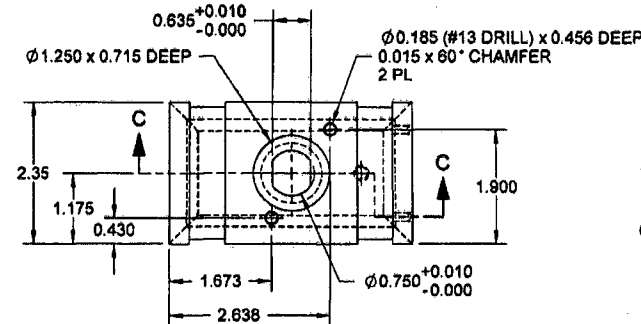
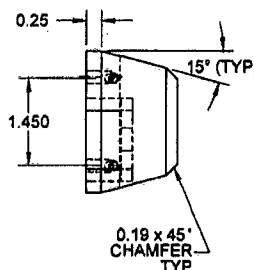
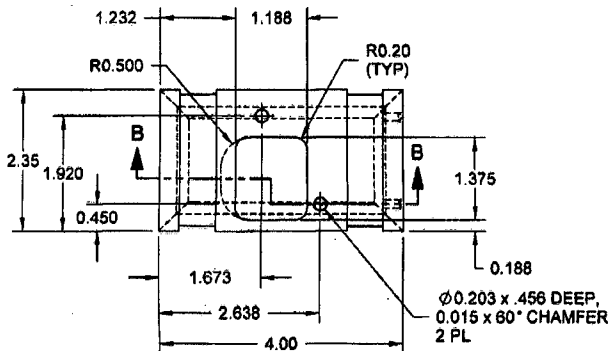
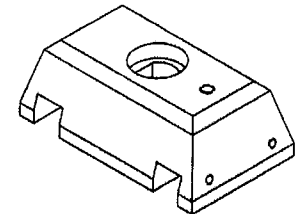
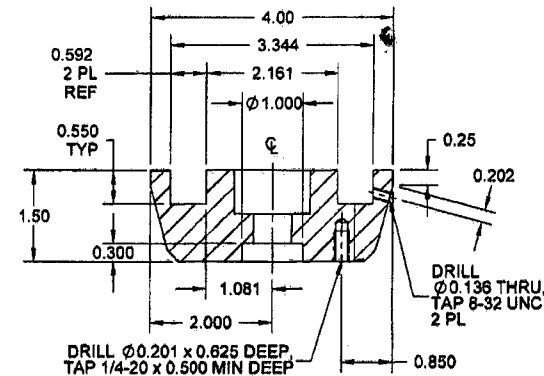
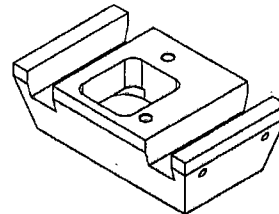
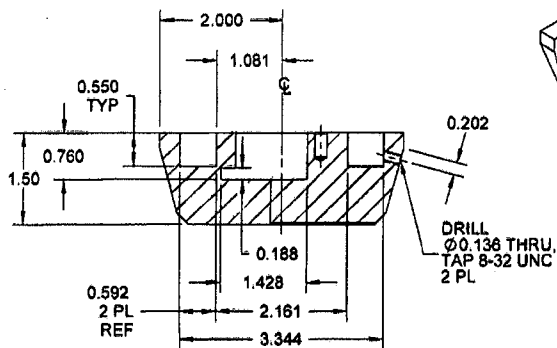
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs



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08-07-11

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	E	DRAWING NO.	REV. C
MFG. APPR.	E	D3370	SHEET 2 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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44287







D3370-1 BASE

D3370-3 COVER

- NOTES:
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
 - 2) COVER INSIDE HOLES PRIOR PAINTING
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

44287

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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